Work Orde Wednesday, May											Page 1
Revision ID: Item Name:	D3643-1 Stiffener 5/19/2010 5/26/2010	Start Qty: 6.00 Req'd Qty: 6.00		Accept	Cust Item I Customer:				Setup Star Stop		1444   14   14   16   1444   16   14   16
Approvals:	Process Pla	an:	Date:/0-5-/5	Tooling: SPC (Y/N):		ite:	<u>.</u>	F	Run Star Stop		
Sequence ID/ Work Center ID		Operation Description	·	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D3643	Rev	v A									
Waterjet FLOW CNC Waterje PLOW CNC Waterje PLOW CNC Waterje PLOW CNC Waterje		FLOW WATER JET  Memo 1-Cut as p Deburr if t  QC2- Inspect parts off  Memo		0.00	<b>A</b> □2-			Sop	10-6-2	·	
120 QC Quality Control		QC8- Inspect parts - se	cond check	اه، کے رور	culos			(48)	)		· <del></del>

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W/O:			W	ORK ORDER CHANG	ES		····		
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NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verifica	tion	Approval	Approval
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NOTE: Date & initial all entries

Work Orde Wednesday, May												Page	2
Revision ID:	D3643-1 Stiffener			Accept					Setup	Start Stop			
	5/19/2010	Start Qty: 6.00 Req'd Qty: 6.00	1 <b>86</b> 410 <b>4</b> 441 <b>484</b> 1   <b>186</b> 410 <b>4</b> 441 <b>186</b>		Cust Item I Customer:	D:						<b>818</b> 11 <b>9</b> 11 <b>8</b> 1 1 <b>98</b> 1	
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ate:	_		Run	Start			
	QC:	·	Date:	_ SPC (Y/N):	Da	ate:				Stop			
Sequence ID/ Work Center ID 130		Operation Description NC BRAKE		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp	
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		Small Fab		0.00				L/	5	/			
Small Fab		Memo		0.00				40	10	106 /	08	$(\mathcal{B})$	-

150

Small Fab

Quality Control

QC5- Inspect part completeness to step on W/O

C'sink as per Dwg D3643

Memo

**3** 



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W/O:	1		WC	ORK ORDER CHANG	GES					•
DATE	STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCF	l: Yes I	No DQ	<b>\</b> :	Date:	
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NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC		Corrective Action , Sec			Verific	ation	Approval	Approval
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NOTE: Date & initial all entries

#### Work Order ID 58834

Wednesday, May 19, 2010 1:08:20 PM



Page 3

Item ID:

D3643-1

Accept



Setup Start



**Revision ID:** 

**Start Date:** 

Item Name: Stiffener

**Required Date: 5/26/2010** 

5/19/2010

Start Qty: 6.00 Req'd Qty: 6.00

**Cust Item ID:** 

**Customer:** 

Reference:

App	orovals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID

160

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours** 

0.00

Draw Number

Draw Rev.

Plan Code Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Memo

Memo

0.00

5 Bb 10-6-8

170



Quality Control

QC3- Inspect Part Finish

10/06/08

180

Packaging

Identify as per dwg & Stock Location: 243.

0.00

Memo

0.00

Packaging

	-								
W/O:			WO	RK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	_ Date: _	
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DATE	STEP	Description of NC	<del></del>		ction B	Verific	eation	Approval	Approval
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, NOTE: Date & initial all entries

#### Work Order ID 58834

Wednesday, May 19, 2010 1:08:20 PM



Page 4

Item ID:

D3643-1

Accept

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name:

Stiffener

5/19/2010

Start Qty: 6.00

**Required Date: 5/26/2010** 

Req'd Qty: 6.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan: \_\_\_\_\_

Date:

Date:\_

Tooling:

SPC (Y/N):

Draw

Number

Date:

Draw

Rev.

Plan

Code

Date:

Qty

Run

Accept

Qty

Stop

Start

Sequence ID/

**Work Center ID** 

QC:

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** 

0.00

0.00

Reject Reject Insp. Number Stamp

Quality Control

190

Memo

W/O:		WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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,NOTE: Date & initial all entries

#### **Picklist Print**

Wednesday, May 19, 2010 1:08:25 PM

Work Order ID: 58834

Parent Item:

**Comments:** 

D3643-1

Parent Item Name:

Stiffener

IPP Rev:A New Issue 07-07-20 JLM

Verified By:EC

112291

112331

113162

Start Date: 5/19/2010

Required Date: 5/26/2010

Page 1

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	487.6000	0.1475	(.2		
2024-T3 040 sheet										(4	B 10-6-2	

2024-T3 .040 sheet

Location	<u>n</u>	Loc Oty	Loc Code	
MAT		96		
	114415	96		_
MAT22		391.6		
	110305	131.1		
	111786	15.5		





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W/O:			WC	ORK ORDER CHANG	SES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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					•				
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
		solution:							
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			tion B	Verifi	cation	Approval	Approval
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, NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	58831
Description: Stiffener	Part Number:	D3643-1
Inspection Dwg: D3643 Rev: A		Page 1 of 1

	x	ARTICLE IN First Artic		Proto			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
Ø0.098	+0.004/-0.001	,099	12				
Ø0.266	+0.006/-0.001	267	*				
1.90	+/-0.030	1.964	<del></del>				
0.96	+/-0.030	,963	*				
1.25	+/-0.030	1-750	4				
2.000	+/-0.010	1,994	*				
4.49	+/-0.030	4,49	<u> </u>				
9.00	+/-0.030	9.00	*				
9.75	+/-0.030	9.75	*				
0.81	+/-0.030	797	*				
0.040	+/-0.010	,040	*				
Measured by: │↓ Date:	3 0-6-2	Audited by:	10/66/0	ხ [	Prototype App	roval: Date:	N/A N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	77

W/O:			V	VORK ORDER CH	IANGES				
DATE STEP		PROCEDURE CHANGE				Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAI		PAR #:	Fault Ca	tegory:	NCI	R: Yes N	lo <b>DQA</b> :	Date: _	
			Disposition: C						
NCR:		V	WORK OR	DER NON-CONFO	DRMANCE	(NCR)			
DATE	STEP	Description of NC	Corrective Action Section B Initial Action Description			Sign &	Verification	Approval	
		Section A	Chief Eng	Chief Eng		Date	Section C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

133 Ø0.098 THRU -BEND LINE C'SINK Ø0.179 X 100° Ø0.266 (2 PLACES) (4 PLACES) GRAIN DIRECTION **+** (+) **+** 0.96 0.81, 0.344 SHOP COPY - 1.25 (TYP) R0.25 (TYP) 1.117 **RETURN TO** - 2.000 **ENGINEERING UNCONTROLLED COPY** С SUBJECT TO AMENDMENT WITHOUT NOTICE **D3643-1F FLAT PATTERN** WORK ORDER (D3643-2F OPPOSITE) NO 58834 ENSURE THAT COUNTERSINKS ARE ON THIS SIDE OF THE PART 0.60 (REF) **\***  $\oplus$  **\* +** (+) **+** 1.41 R0.13 D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2) D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1) NEW ISSUE; REPLACES G10610 07.07.27 IE REV. DATE DESCRIPTION BY NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) SPEAK SUARD EDGES: 0.005 TO 0.010 MAY DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3643 MFG. APPR. SHEET 1 OF **APPROVED** TITLE SCALE 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3643-1/-2" USING FINE POINT PERMANENT INK MARKER **STIFFENER** DE APPR:

5

COPYRIGHT © 2007 BY DART AEROSPACE LTD

DATE

07.07.27

7) WEIGHT: 0.06 lbs

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W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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DATE	STEP	<b>Description of NC</b> Section A	Corrective Action Section B			Verific	cation	Approval	Approval			
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NOTE: Date & initial all entries